

ITEM #	QTY	PART #	PART TITLE
-1	1	RBE117-60000-W6-1	DISK ASSEMBLY
-3	1	RBE117-60000-W6-3	POINTER ASSY

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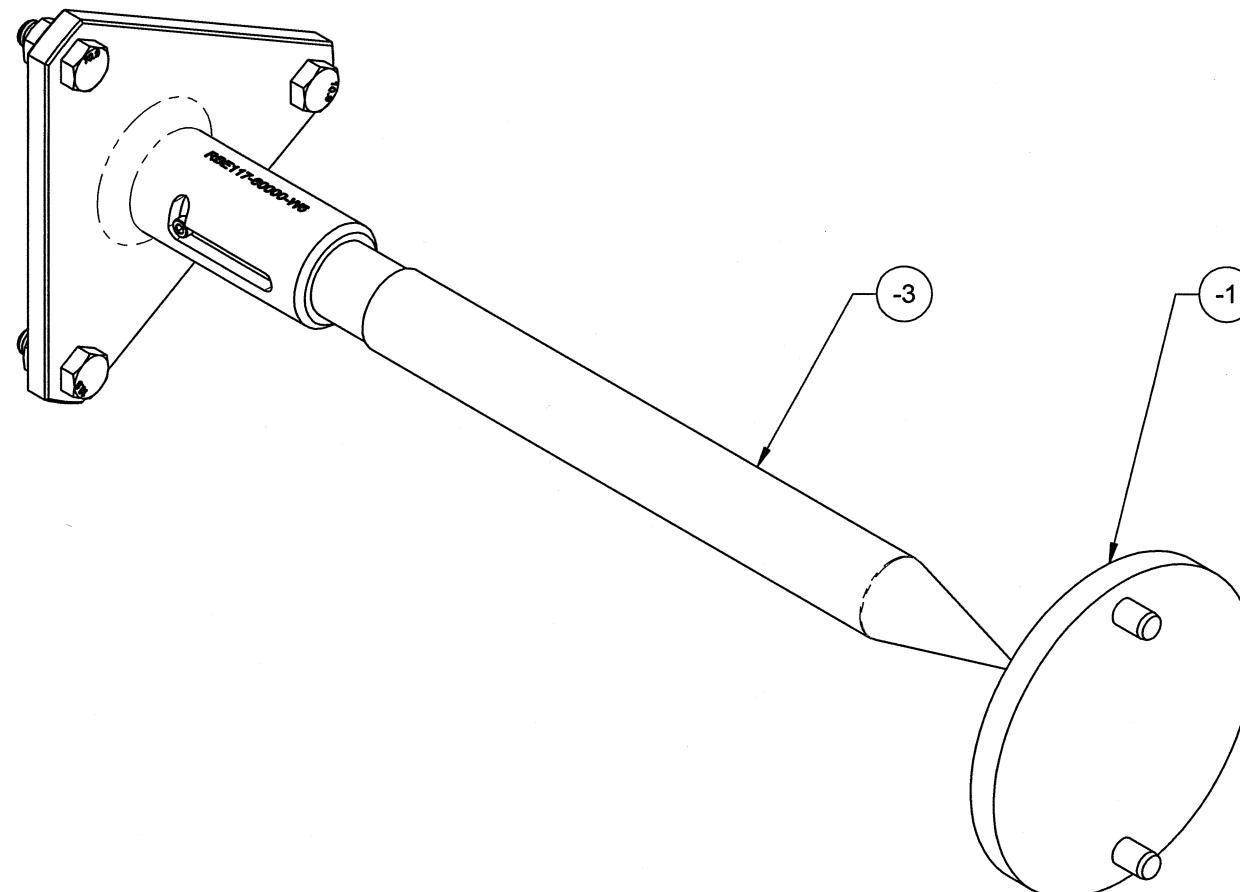
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RBE117-60000-W6 ALIGNMENT DEVICE

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NOTES:

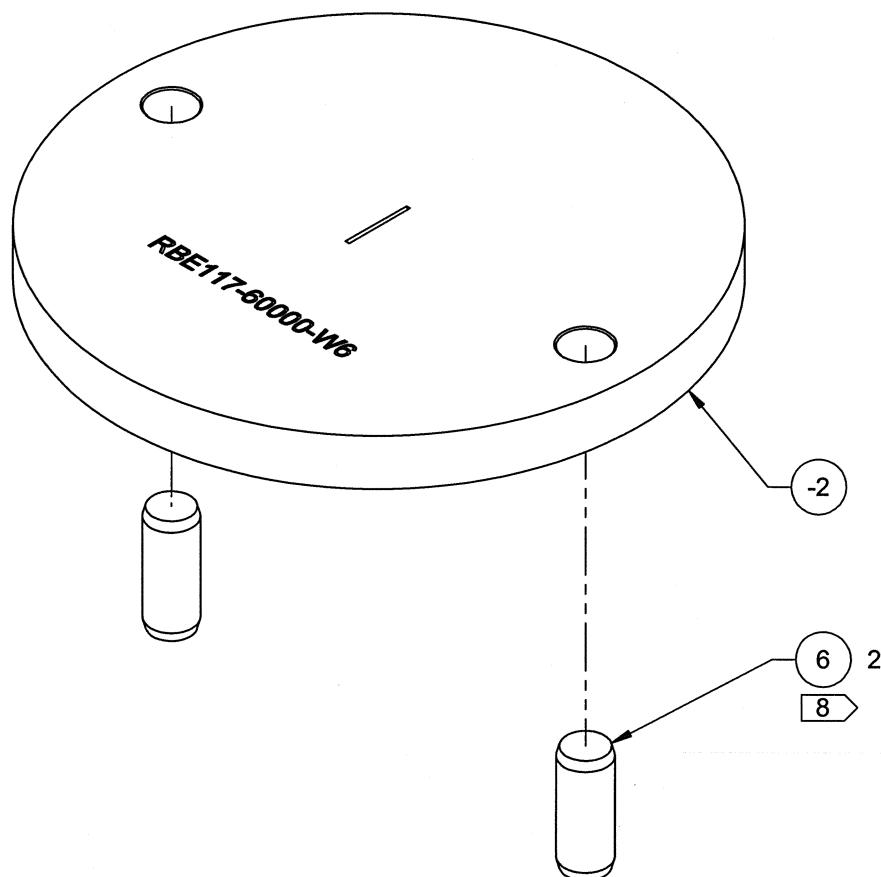
- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH:
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

A	NEW ISSUE	19-747	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	REV. A	
MFG. APPR.	JFC	TOOL PART #	
APPROVED	VJ	RBE117-60000-W6	
DATE 2019-05-30		SHEET 1 OF 6	
TITLE ALIGNMENT DEVICE		SCALE	NTS
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ITEM #	QTY	PART #	PART TITLE
-2	1	RBE117-60000-W6-2	DISK
6	2	McMaster#93600A697 OR EQUIV	SS316 DOWEL PIN 8mm DIA. X 20mm LG.

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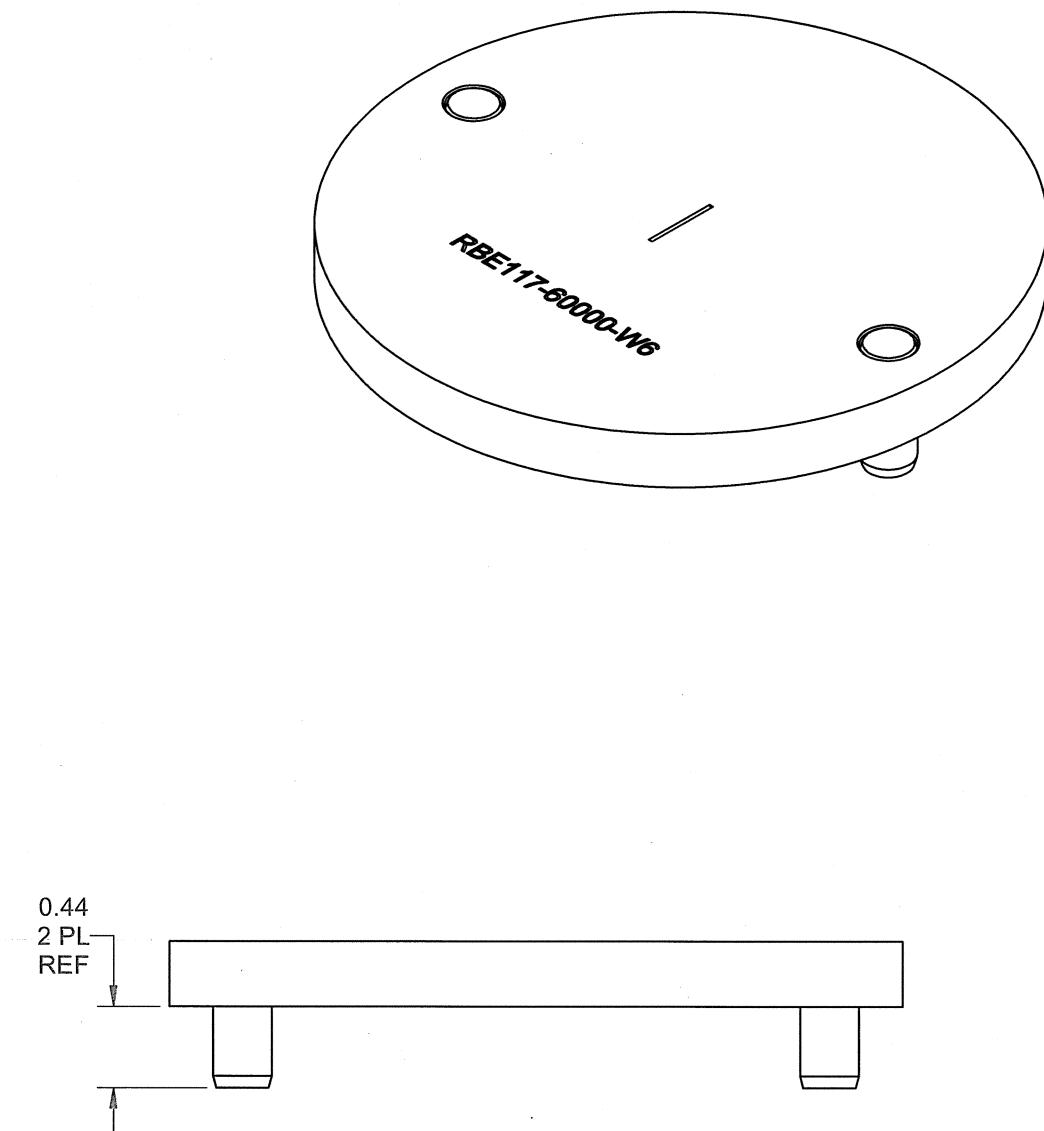
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RBE117-60000-W6-1 DISK ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH:
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 6 FLUSH TO SURFACE OF ITEM -2 AS SHOWN, AND REMOVE EXCESS



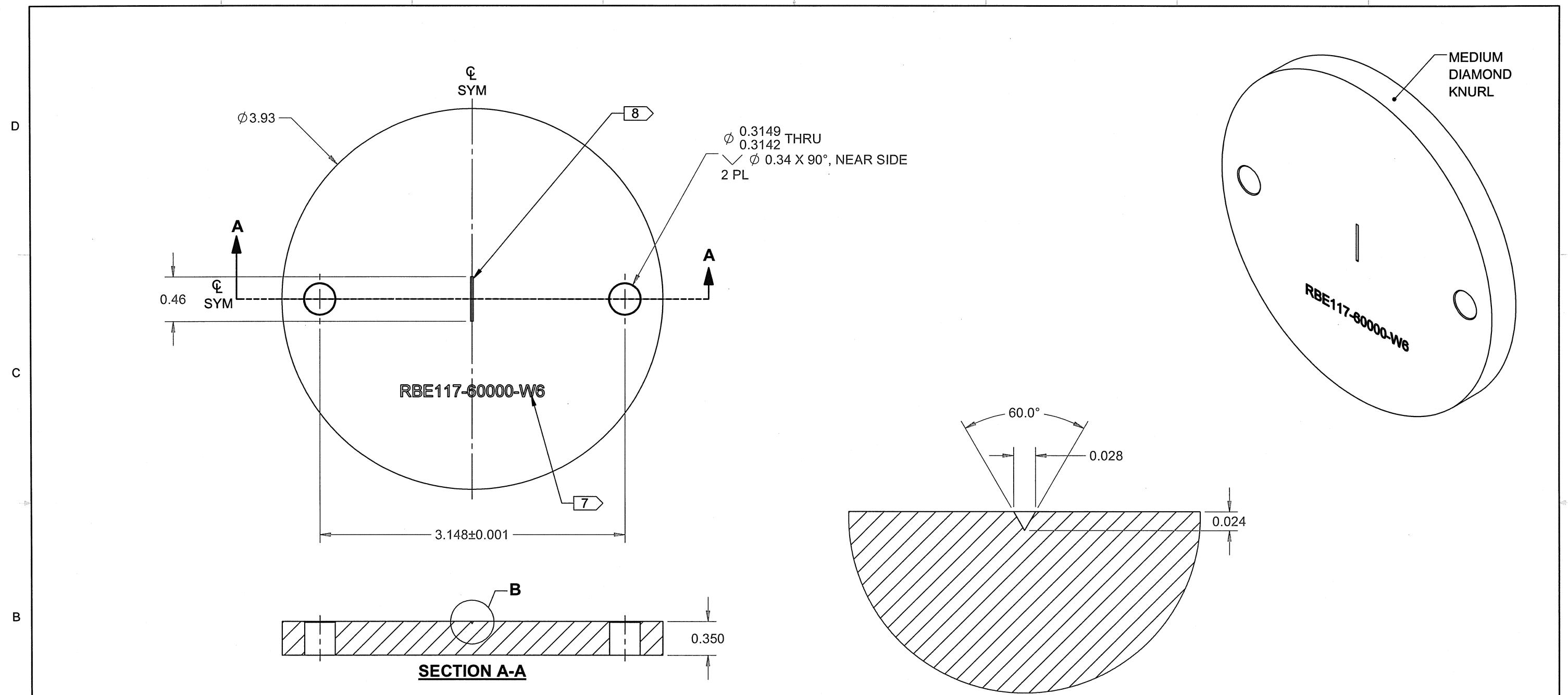
DESIGN	VM
DRAWN	VM
CHECKED	KPT
MFG. APPR.	JFC
APPROVED	WJP

DATE 2019-05-30

DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA	
TOOL PART #	RBE117-60000-W6
REV. A	SHEET 2 OF 6
TITLE ALIGNMENT DEVICE	
SCALE	NTS

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RBE117-60000-W6-2 DISK

NOTES:

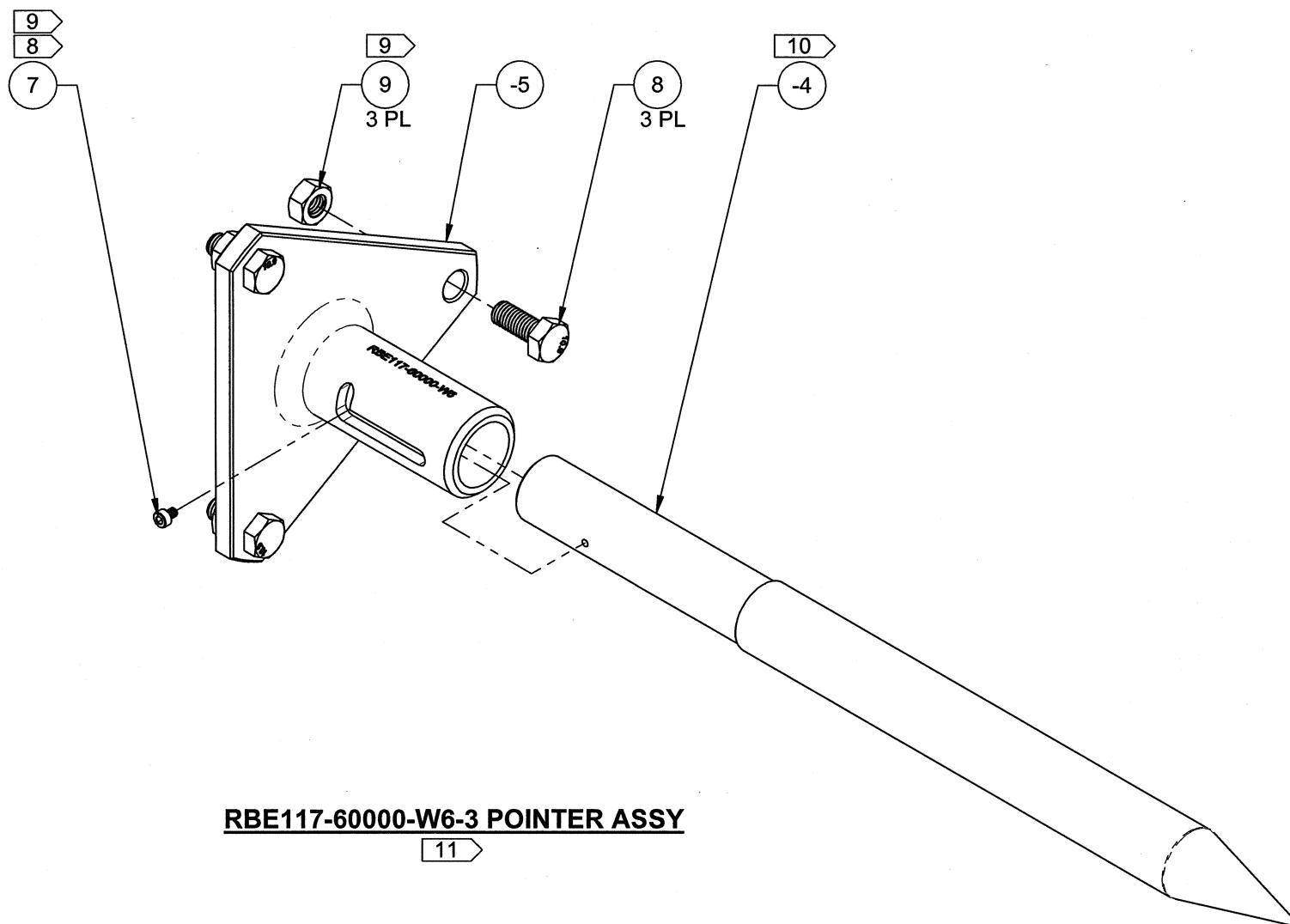
- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = $+\/- 0.1"$ / $+\/- 1^\circ$
 $X.XX = +/\- 0.01"$ / $+\/- 0.5^\circ$
 $X.XXX = +/\- 0.005"$ / $+\/- 0.1^\circ$
 $X.XXXX = +/\- 0.0005"$ / $+\/- 0.05^\circ$
- 5) PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+\/- 0.005"$
- 6) UNITS: INCHES UNLESS OTHERWISE NOTED
- 7) REMOVE ALL SHARP EDGES AND BURRS
- 8) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBE117-60000-W6", AS SHOWN
- 9) SCRIBE LINE NEED TO BE FILLED WITH BLACK INK

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	
MFG. APPR.	JFC	
APPROVED	WJ	
DATE	2019-05-30	
TOOL PART #	RBE117-60000-W6	REV. A
TITLE	ALIGNMENT DEVICE	SHEET 3 OF 6
SCALE	NTS	(Scale icons)

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ITEM #	QTY	PART #	PART TITLE
-4	1	RBE117-60000-W6-4	POINTER
-5	1	RBE117-60000-W6-5	BASE
7	1	McMaster#92290A108 OR EQUIV	SS316 SOCKET HEAD SCREW M3 X 0.5mm X 4mm LG.
8	3	McMaster#90854A164 OR EQUIV	ZINC YELLOW PLATED GRADE 10.5 STEEL HEX HEAD SCREW M8 X 1.25mm X 20mm LG.
9	3	McMaster#92497A400 OR EQUIV.	ZINC YELLOW PLATED GRADE 10 STEEL HEX NUT M8 X 1.25mm X 6.5mm HT.

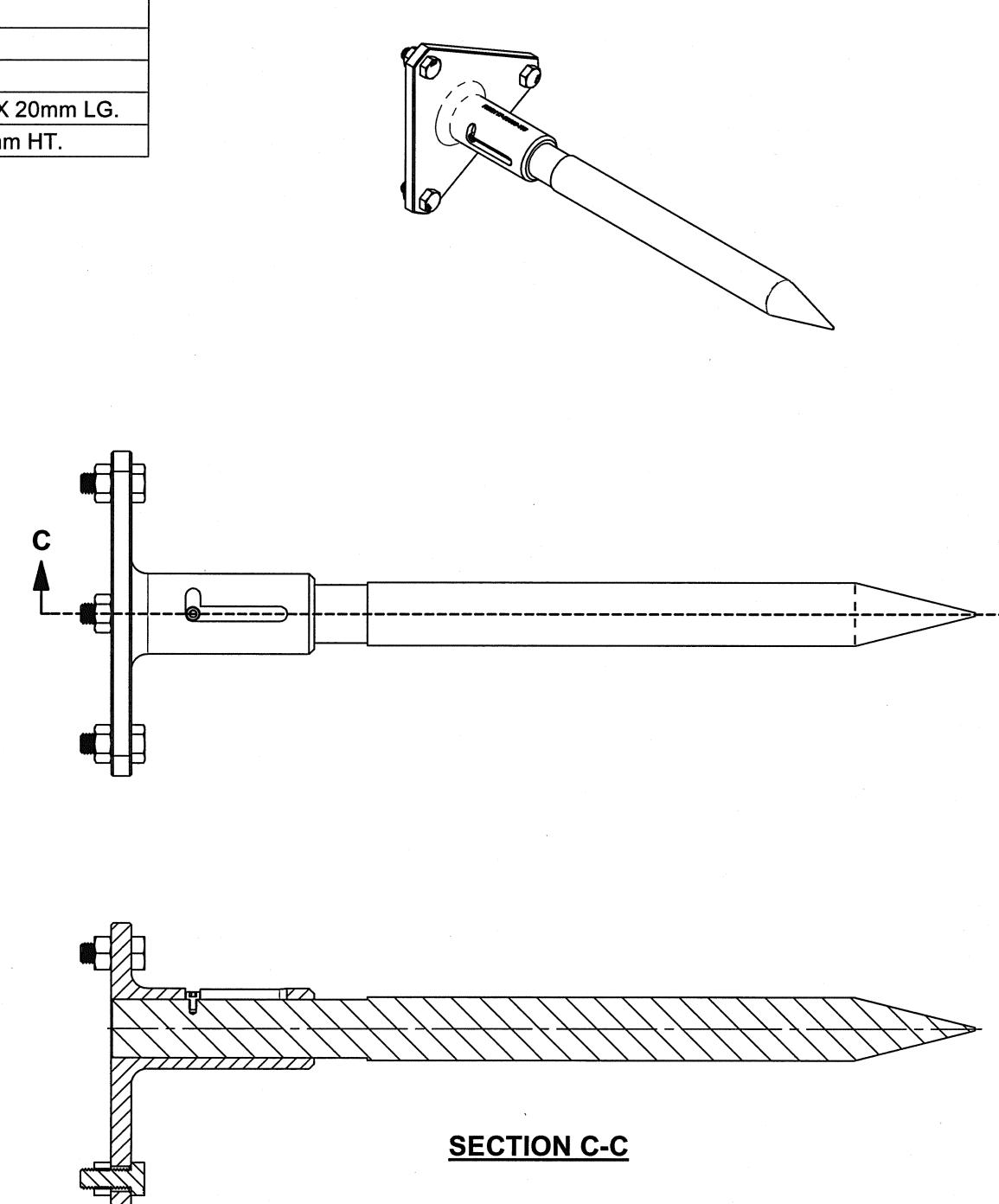


RBE117-60000-W6-3 POINTER ASSY

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NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: $X.X = +/- 0.1"$ / $+/- 1^\circ$
 $X.XX = +/- 0.01"$ / $+/- 0.5^\circ$
 $X.XXX = +/- 0.005"$ / $+/- 0.1^\circ$
 $X.XXXX = +/- 0.0005"$ / $+/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 7 THEN ASSEMBLE WITH ITEM -4, AND REMOVE EXCESS
- 9) INSTALL ITEM 7 AND ITEM 9 HAND TIGHT
- 10) ITEM -4 MUST SLIDE FREELY ALONG ITEM -5
- 11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	REV. A	
MFG. APPR.	JFC	TOOL PART #	
APPROVED	WJ	RBE117-60000-W6	
DATE 2019-05-30		TITLE ALIGNMENT DEVICE	
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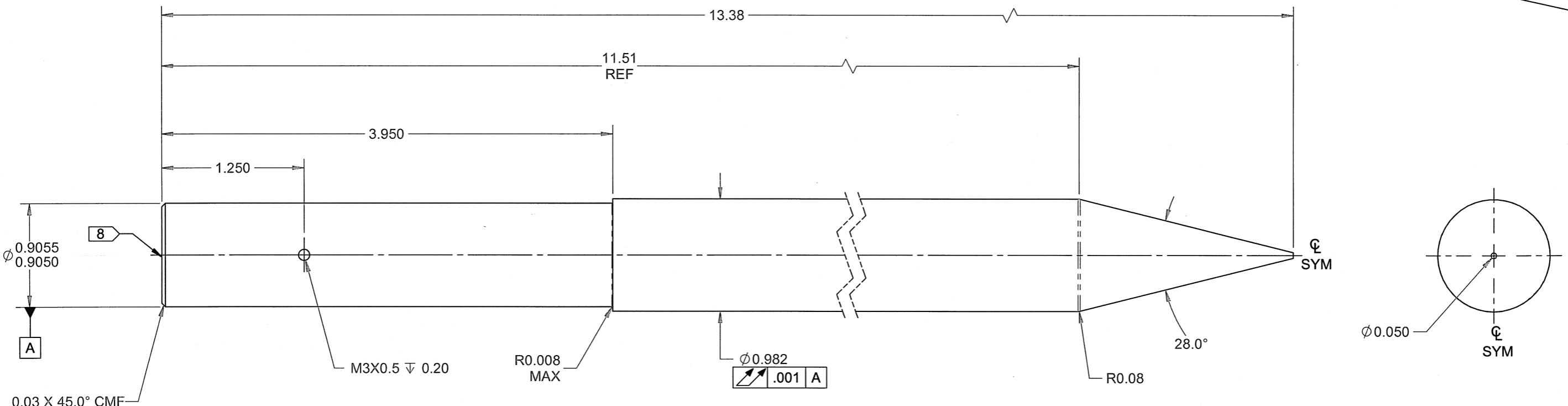
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RBE117-60000-W6-4 POINTER

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN DRAWN	VM VM	DART AEROSPACE LTD
CHECKED	KPT	HAWKESBURY, ONTARIO, CANADA
MFG. APPR.	JFC	REV. A
APPROVED	WJ	TOOL PART # RBE117-60000-W6
DATE 2019-05-30		SHEET 5 OF 6
		TITLE ALIGNMENT DEVICE
		SCALE NTS
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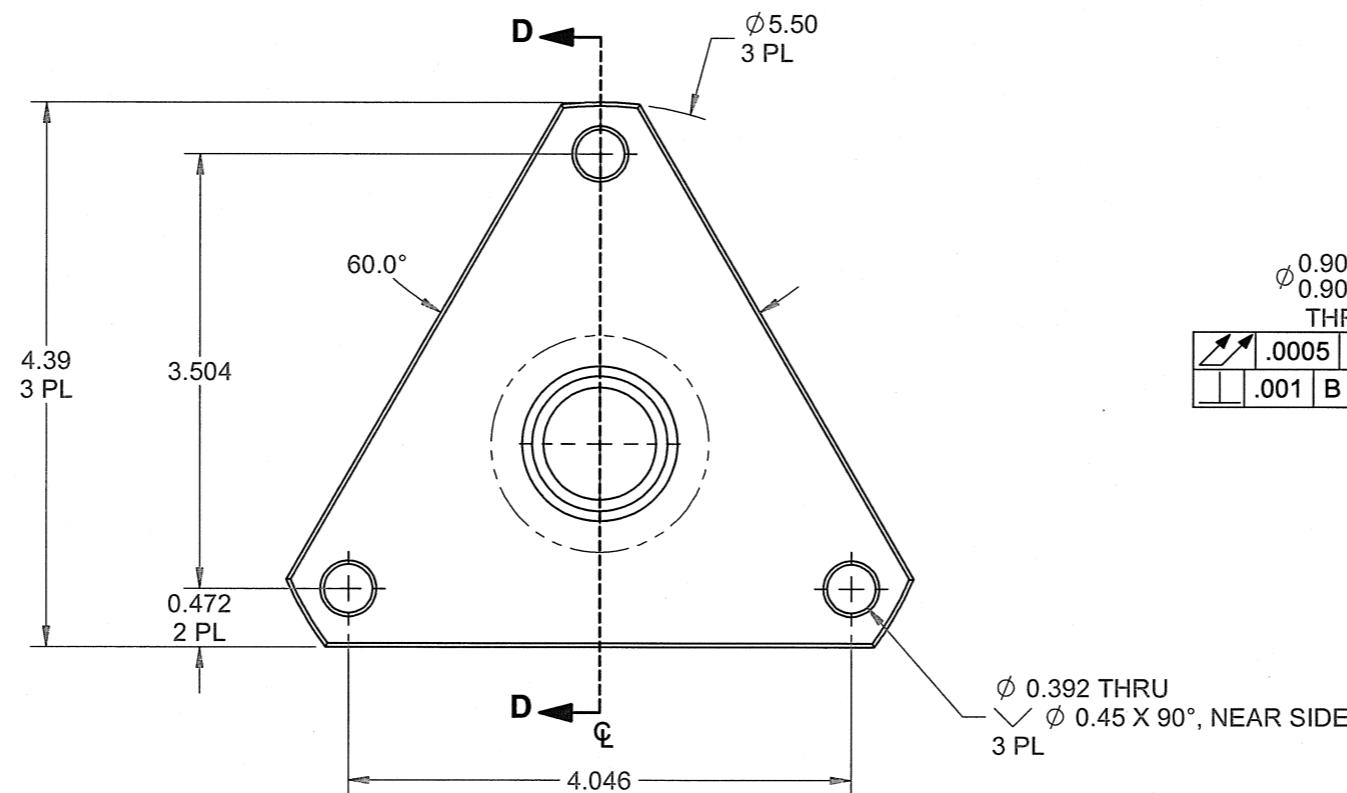
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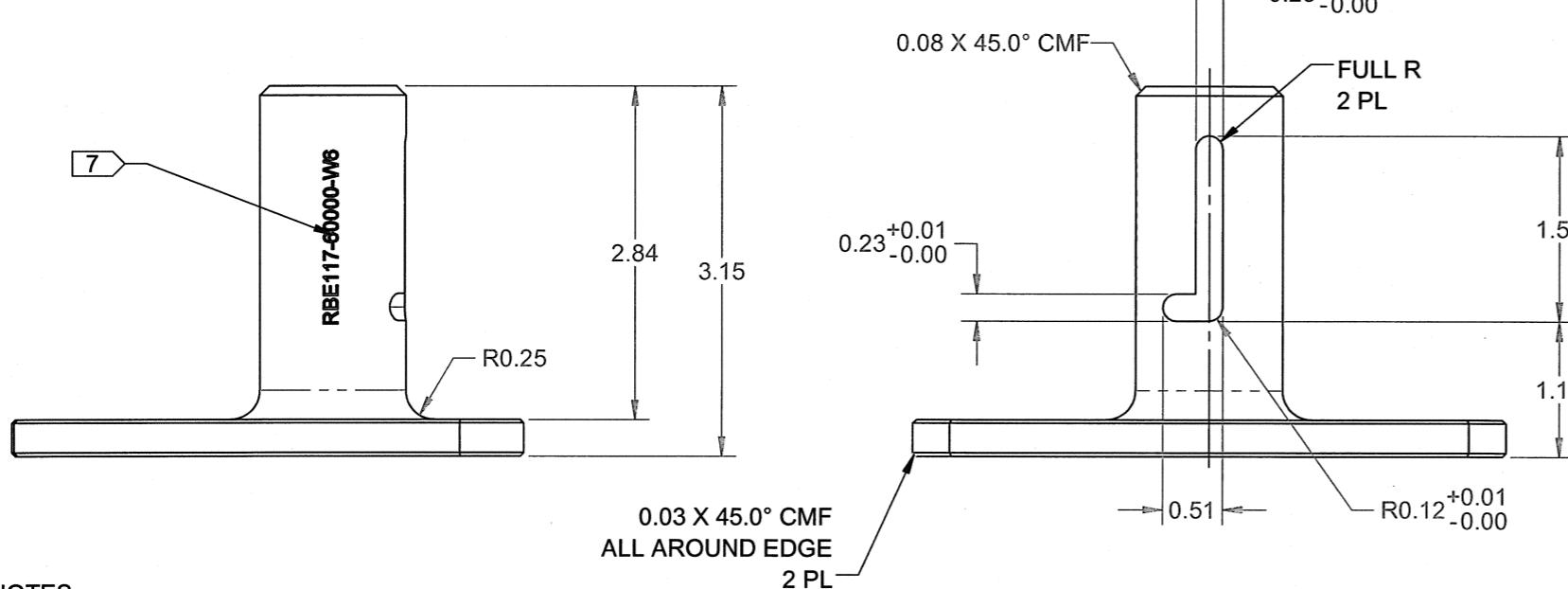
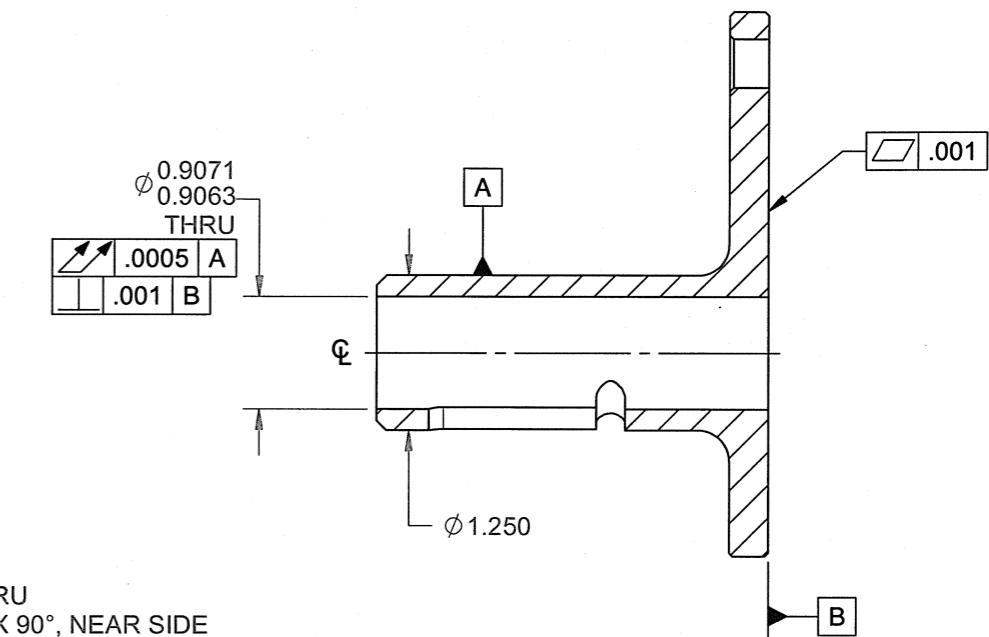
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SECTION D-D



RBE117-60000-W6-5 BASE

NOTES:
1) MATERIAL: 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBE117-60000-W6", AS SHOWN

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBE117-60000-W6	SHEET 6 OF 6
APPROVED	<i>VJF</i>	TITLE	SCALE
		ALIGNMENT DEVICE	NTS
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